

Work Order ID 78045-1

December-28-11 8:12:47 AM

split

78045

Page 1

Item ID: D3910-3

Revision ID:

Item Name: Crosstube Lug

Start Date: 28/12/2011 Start Qty: 40.00

Required Date: 12/01/2012 Req'd Qty: 40.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: *M.L.J.*

QC:

Date: 11/12/28

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3910

B

100

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

Cut to 1.450" Long

0.00

Cut to 1.450"

110

0.00

110

HAAS I

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA865 AND DWG
FOLIO REV.
DWG REV.

0.00

DEBURR

issue Pro for meter 270.1576.4

of per (long) 1.450" R.P.D. B

CL 1210103

CL 1210103 70

B 10/1/10

Work Order ID 78045

December-28-11 8:12:47 AM

78045

Page 2

Item ID: D3910-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Lug

Start Date: 28/12/2011 Start Qty: 40.00

40

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

acc'd + images for transfer damage
attached c/c to work

Handwritten signature

130

130

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Handwritten note: Sizelock

Handwritten circled 6

140

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Handwritten circled 6

Handwritten note: CF/M 12-1-11

Work Order ID 78045

December-28-11 8:12:47 AM

78045

Page 3

Item ID: D3910-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Lug

Start Date: 28/12/2011 Start Qty: 40.00

40

Cust Item ID:

Required Date: 12/01/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

Powder Coating

Start Time: 10:20
Temp: 320°F
Finish Time: 10:50

6x of m-12/01/11

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

Quality Control

to d all 12/01/11
counted & identified

170

Identify as per dwg & Stock Location: ST 507 - 0.00

170

Packaging

Memo

0.00

Packaging

6x SP 12-01-12.

Work Order ID 78045

December-28-11 8:12:47 AM

78045

Page 4

Item ID: D3910-3

Revision ID:

Item Name: Crosstube Lug

Start Date: 28/12/2011 Start Qty: 40.00

Required Date: 12/01/2012 Req'd Qty: 40.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/1/12
mf
12-01-12

Picklist Print

December-28-11 8:12:51 AM

Page 1

Work Order ID: 78045

Parent Item: D3910-3

Parent Item Name: Crosstube Lug

78045

D3910-3

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	411.0900	0.13	5.473684			
D2423									**				
Lug Extrusion													

CA 12/01/03

Location

MAT006

Loc Qty

411.09

43722

161.5

45800

1

68331

248.59

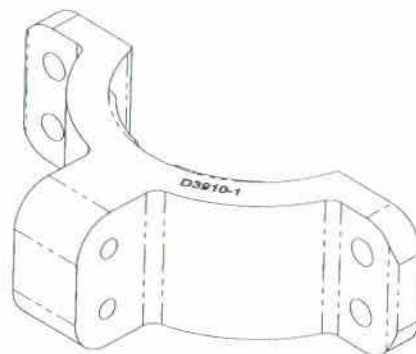
Loc Code

5.48

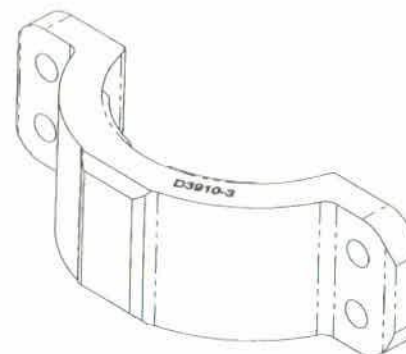
D 3910-3P

X 40

12/4/10 (6)



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

RELEASED
2010-03-22
MD

78045 M.L.J
11/12/28

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

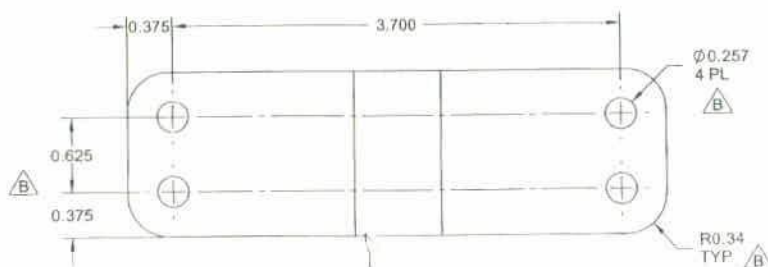
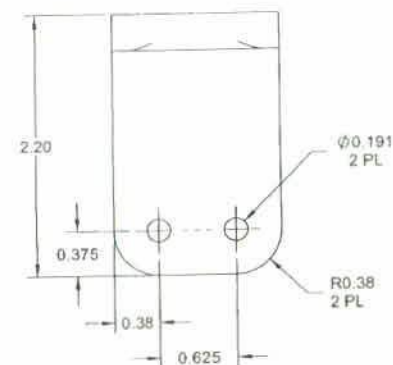
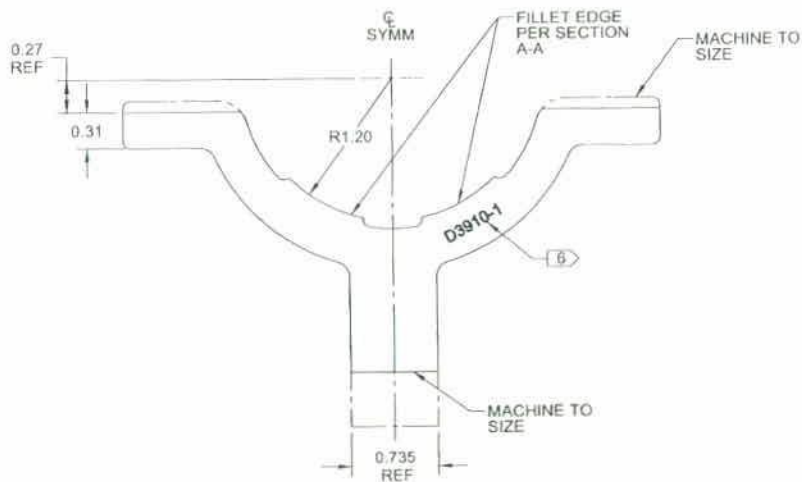
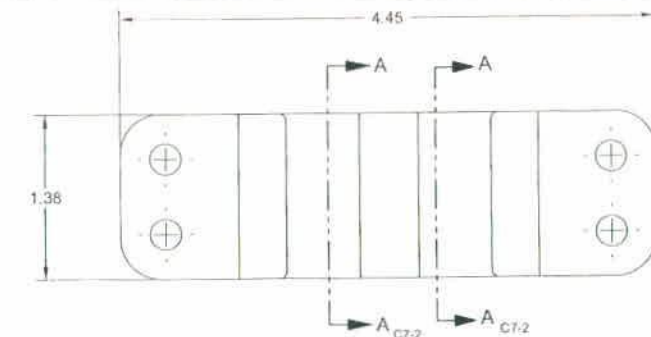
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3) REASON: SEE TR-D3910-007-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3910 REV. B TITLE X-TUBE LUG (350) SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES FOR WHICH IT WAS SUPPLIED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	JPH			
CHECKED	JPH			
MFG. APPR.	JPH			
APPROVED	JPH			
DE APPR	JPH	DATE 10.03.16		

78045

SECTION A-A
C4-2
C5-2



ROUND EDGE
R0.05 MIN - R0.10 MAX
2 PL

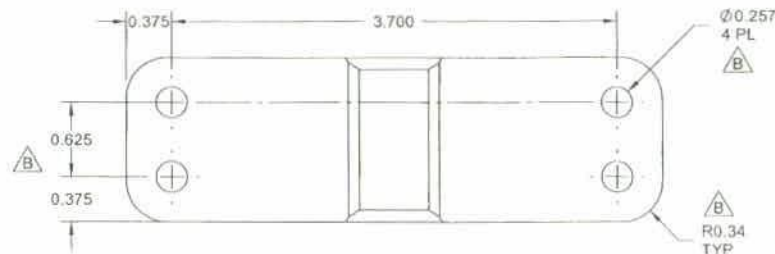
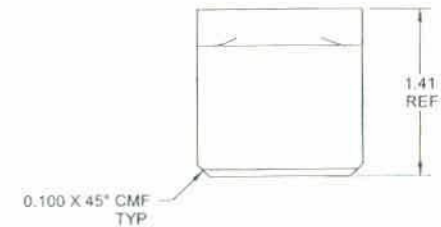
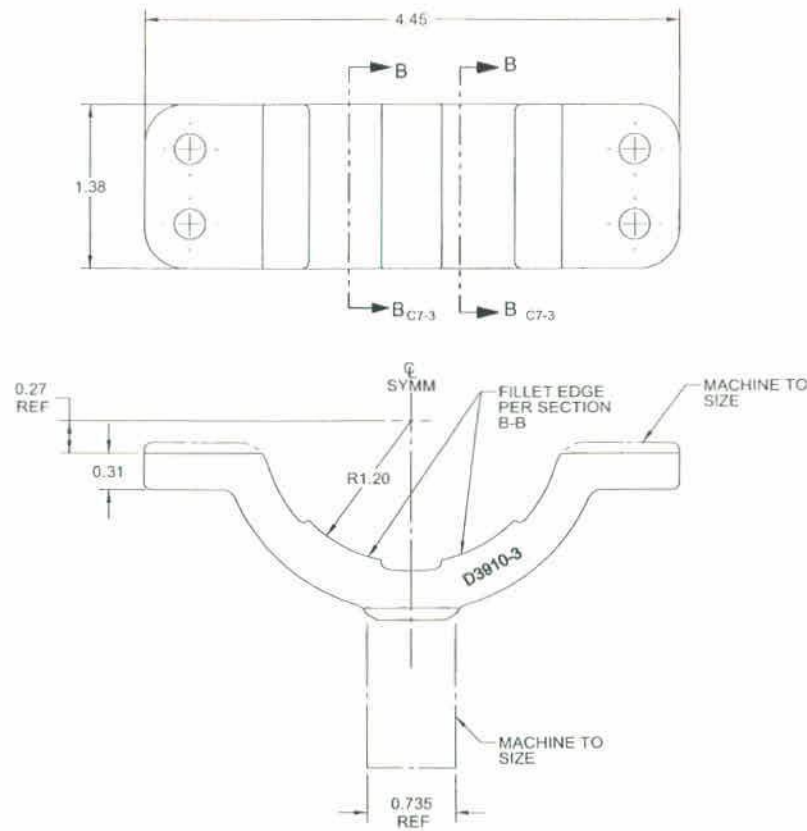


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2010-03-22

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MFG. APPR.		D3910	SHEET 2 OF 3
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DE APPR.		X-TUBE LUG (350)	NTS
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78045

SECTION B-B
C4.3
C5.3
ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-3 X-TUBE LUG

RELEASED
2010-03-22

DESIGN	A4S	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. B
MFG. APPR		D3910	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR		X-TUBE LUG (350)	NTS
DATE	10.03.16	COPYRIGHT © 2015 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15764

Purchase Order Date 1/03/12

PO Print Date 1/03/12

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Contact Name

Vendor Phone 613 678 3957

Vendor Fax 613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

EX 1000 1/03

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D3910-3P		Crosstube Lug	1/13/12 Yes	40.00 Each	Dart Truck	\$31.5500	\$1,262.00

MC QUG

Special Inst: AS PER DWG D3910 REV. B
B78045

PO Total:

\$1,262.00

MC 2

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 1/03/12



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18398
Date: Jan 10, 2012
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO15764	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
3910-3 Crosstube Lug as per drawing U3910 REV. B B78045 Material supplied by DART: D2423 B68331	Each	40	6	34
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Sizulu

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

6

D3910-3

Crosstube Lug

15764

MATERIAL: supplied by DART D2423 B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, January 10, 2012